

**ABSTRACT OF THE DISCLOSURE**

A process for manufacturing, in one stage, a tire comprising a carcass reinforcement (1) which is radial in the sidewalls and oblique radially beneath a crown reinforcement (3), composed of at least two layers (31) and (32) of reinforcement elements (310) and (320) which are crossed from one layer to the next, wherein there is pre-shaped to a diameter  $D_1$  and by means of a sleeve of at least one shaping ply N, vulcanized and formed of reinforcement elements forming with the circumferential direction an angle  $\alpha_1$ , laid on the building drum T of diameter D, at least the central part of a carcass reinforcement ply (1) formed of radial reinforcement elements (10) forming with the circumferential direction an angle  $\mp \beta_1$ . There is laid on the central part at least one crown ply (31, 32) formed of reinforcement elements (310, 320) oriented relative to the circumferential direction at angles  $\pm \gamma_1$  ( $\mu \gamma_1$ ),  $\gamma_1$  being little different from  $\beta_1$ . Shaping is effected by bringing the internal diameter  $D_1$  of the cylindrical blank to the internal diameter  $D_2$ , which is the diameter of the vulcanized tire.

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